

Work Order ID 147965

Friday, June 17, 2016 7:59:59 AM

147965

Page 1

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw 19" X 24"
Start Date: 6/3/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 6/17/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLS Date: JUN 20 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	H								

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.30

FLOW CNC Waterjet

Cut Blank as per D2432 File

142-16/07/12

130

0.09

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.90

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

14Ø

DAS
33
9-89
14/07/12
DAS
44
9-89
16-07-30

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.02

Quality Control

14Ø

DAS
33
9-89
14/07/12
DAS
44
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 147965

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147965

Page 2

Item ID: D2432

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw 19" X 24"

Start Date: 6/3/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00				14	0		DAS 45 9-89 2016-8-3
150									
QC	Memo	0.04							
Quality Control									
160	Identify as per dwg & Stock Location: <u>St</u>	0.00				14			
160									
Packaging	Memo	0.02							DAS 6 9-89 AUG 8 2016
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.20							DAS 21 9-89 AUG 04 2016
Quality Control									

SW 8/3/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Friday, June 17, 2016 7:59:58 AM

Page 1

Work Order ID: 147965

147965

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 6/3/2016

Required Date: 6/17/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	623.3580	3.7	44.4			

MUHMWB10

De 16/07/12

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	16.9	
m134171	16.9	
MAT018	606.458	
m131661	1.473	
m134372	27.485	
m134823	177.5	54
m135013	400	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	147965
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

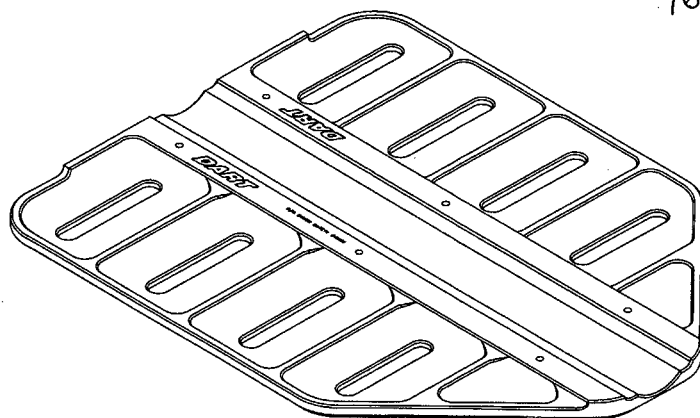
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.053 x 45°	✓		Vern	FK-04
B	0.200	+/-0.030	.202	✓		"	"
C	0.25 x 45°	+/-0.030	.25 x 45°	✓		"	"
D	R0.250	+/-0.030	.250	✓		R-G	
E	0.250	+/-0.010	.251	✓		Vern	FK-04
F	0.625	+/-0.030	.620	✓		"	"
G	0.375	+0.030/-0.010	.391	✓		"	"
H	0.950	+/-0.030	.964	✓		"	"
I	19.000	+/-0.030	19.000	✓		Tape	FK-05
J	Ø0.260	+0.005/-0.000	0.260	✓		MIP-04	vern
K	Ø0.93	+/-0.030	0.930	✓		↓	↓
L	0.30	+0.030/-0.000	0.320	✓			
M	23.750	+/-0.030	23.75	✓		Tape	FK-05
N	2.000	+/-0.030	1.990	✓		Vern	FK-04
O	0.38	+/-0.030	.375	✓		"	"
P							
Q							
R							
S							
T							
U							
V							

Measured by:	DAS 33 9-89	DAS 44 9-89	Audited by:	DAS 45 9-89	Preliminary Approval:	
Date:	16/07/29	16-07-30	Date:	2016-8-3	Date:	

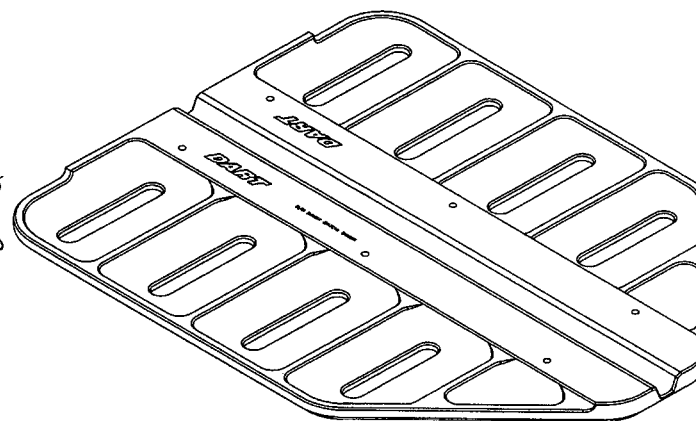
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 147965 MJS

16-06-28



D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
2012-10-16

REV.	DESCRIPTION	BY	DATE
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	91	D2432	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	11	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

